

Abstract

A control system (60) controls a material handling system and has a first control module (120), a second control module (140), and a third control module (160).
5 The first module (120) includes a first control cabinet (12) for providing primary control to the first module (120), a first external component (20) for controlling an equipment component of the material handling system, and a modular interconnectivity
10 component (30) for interconnecting the first control cabinet (12) and the first external component (20) for control of the first external component (20). The control system (60) further includes a first internal component (20) for operating the first control
15 cabinet (12) and a modular interconnectivity component (30). The first module (120) has primary control of the second module (140) and the third module (160). The first module (120) is interconnectable and interoperable with the second module (140) and the
20 third module (160) such that the second module (140) may assume operational control of the third module (160) in the event that the first module (120) is removed from the control system (60).